



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-121
Job Sheet 175974



003374

Part No: D350-591-121

Job Qty: 6 ea

Part Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/13/18

Job Tracking No:

Due Date: 5/23/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG IIN-D350-591 REV H, D2351-041 REV E IPP Rev:E 02.10.21 Re-format; Incorporated D2351-041 IPP KJ/RF IPP rev. F 06.02.23 added grinding EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	5/22/18	5/22/18	0.00	0.00	Start Up Large Fab-4		DG 2018-04-25
110	Large Fab	6 pcs	5/22/18	5/22/18	0.00	4.08	Large Fab 8		DG 2018-04-25
120	CNC Bend Skid tubes	6 pcs	5/22/18	5/22/18	0.38	1.76	CNC Bend Skid tube		DAS 38
122	QC	6 pcs	5/22/18	5/22/18	0.00	0.00	QC5		SLV 9-88
140	Large Fab	6 pcs	5/22/18	5/22/18	0.00	4.08	Large Fab 2		CPC
150	QC	6 pcs	5/22/18	5/22/18	0.00	0.00	QC9		CPC
160	QC	6 pcs	5/22/18	5/22/18	0.00	0.00	QC5		CPC
170	HandFinish	6 pcs	5/22/18	5/22/18	0.00	1.11	HandFinish1		SA 18-05-08
180	QC	6 pcs	5/22/18	5/22/18	0.00	0.00	QC7-2		CPC
190	Large Fab	6 pcs	5/22/18	5/22/18	0.00	4.08	Large Fab 2		DG 2018-05-23
220	QC	6 pcs	5/22/18	5/22/18	0.00	0.00	QC10		CPC
230	QC	6 pcs	5/22/18	5/22/18	0.00	0.00	QC5		CPC
240	HandFinish	6 pcs	5/22/18	5/22/18	0.00	1.11	HandFinish1		SA 18-05-23
250	Powdercoat	6 pcs	5/22/18	5/22/18	0.00	0.97	Powdercoat1		DA 18-5-23
260	HandFinish	6 pcs	5/23/18	5/23/18	0.00	1.11	HandFinish3		BE 18-05-24
270	QC	6 pcs	5/23/18	5/23/18	0.00	0.00	QC3		38
280	Packaging	6 pcs	5/23/18	5/23/18	0.00	0.00	Packaging1-3		68 MAY 25 2018
290	QC	6 pcs	5/23/18	5/23/18	0.00	0.00	QC4		9 MAY 25 2018
295	DC	6 pcs	5/23/18	5/23/18	0.00	0.00	DC		9 MAY 25 2018
300	Packaging	6 pcs	5/23/18	5/23/18	0.00	0.00	Packaging3-1		9 MAY 25 2018
310	QC21-FG	6 Ea	5/23/18	5/23/18	0.00	0.00	QC21		DAS 21 MAY 25 2018

Part Op 110 - 1-Cut D2244-116 extrusion to 55.32" long as per Dwg D2351 2- Drill holes as per dwg using DT8230.

Descriptions/ 120 - Bend as per Dwg D2351-041 using CNC Bender 1 and Folio FT011. Use Bend Program D2351-041. Use DT8033 jig to make sure bend is good and fits the jig.

140 - 1-Bevel Fwd and Aft end for welding 2-Weld Aft End Bracket per QSI 004 & Dwg D2351 using Welding Jig DT8033 A/RAluminum Rod 1138673 3-Do not Grind Flush

190 - 1-Rivet Leg Assembly as per Dwg D2351 2-Weld Fwd End Plate per QSI 004 & Dwg D2351 A/RAluminum Rod 1138673 3-Grind end plate flush.

250 - START TIME: 9:10 OVEN TEMPERATURE: 300° FINISH TIME: 9:40

295 - Photocopy bluefile and type labels as per PPP D350-591-121 CHG005

300 - Identify and pack for shipping as per PPP D350-591-121 Location:FG039

3037

Wing Walk 1138711

Plex 4/13/18 8:06 AM Dart.Gagnon.Michelle

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	3 Ea (.5 ea)	90-Start up Operation	5014552
D2850-1	End Bracket	6 Ea (1 ea)	140-Large Fab	5x 5052885 7x 5063804
D2582	Hi-Skid Step Leg Assembly	6 Ea (1 ea)	190-Large Fab	5072948
D2673-34	End Plate	6 Ea (1 ea)	190-Large Fab	
MS20600-AD4W3	Cherry Rivet	96 Ea (16 ea)	190-Large Fab	5058156 (6x) 50626
AN3-37A	Bolt	12 Ea (2 ea)	280-Packaging	
AN4-13A	Bolt	6 Ea (1 ea)	280-Packaging	
AN4-16A	Bolt	12 Ea (2 ea)	280-Packaging	
D2230-1	Mounting Lug	6 Ea (1 ea)	280-Packaging	
D2230-3	Mounting Lug	6 Ea (1 ea)	280-Packaging	
D2732-030	Rubber Cushion - 3"	12 Ea (2 ea)	280-Packaging	
MS21042L3	Nut	12 Ea (2 ea)	280-Packaging	
MS21042L4	Nut	18 Ea (3 ea)	280-Packaging	
NAS1149D0363J	Washer	24 Ea (4 ea)	280-Packaging	
NAS1149D0463J	Washer	36 Ea (6 ea)	280-Packaging	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2244-116	3	152	0
140-Large Fab	D2850-1	6	1	0
190-Large Fab	D2582	6	1	0
	D2673-34	6	21	0
	MS20600-AD4W3	96	393	0
280-Packaging	AN3-37A	12	90	0
	AN4-13A	6	712	0
	AN4-16A	12	312	0
	D2230-1	6	36	0
	D2230-3	6	71	0
	D2732-030	12	353	0
	MS21042L3	12	2,458	0
	MS21042L4	18	3,323	0
	NAS1149D0363J	24	2,782	0
	NAS1149D0463J	36	5,063	0

Part Specifications	
Specifications could not be found.	

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Container No: S065027



Part: D350-591-121

Job No: 175974

Serial No/Batch: S065027

Revision:

Inspector:

Date: 04/25/18



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
003374	S073862	AN3-37A	Bolt	S041154	ST347	12
003374	S073859	AN4-13A	Bolt	S062374	ST344	6
003374	S073858	AN4-16A	Bolt	S068654	ST343	12
003374	S073825	D2230-1	Mounting Lug	S065883	ST521	6
003374	S071128	D2230-3	Mounting Lug	S071113	ST521	1
003374	S073815	D2230-3	Mounting Lug	S065889	ST521	5
003374	S073804	D2732-030	Rubber Cushion - 3"	S059609	ST410	12
003374	S073811	MS21042L3	Nut	s054107	ST303	12
003374	S073810	MS21042L4	Nut	s056039	ST303	18
003374	S073808	NAS1149D0363J	Washer	s015269	ST263	24
003374	S073807	NAS1149D0463J	Washer	s055952	ST263	36

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

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5.0 PARTS LIST

Qty -117A	Qty -119	Qty -133	Part Number	Description
X			D350-591-117A	<i>Heli-Access-Step</i> ™, Pre-Flight Step
	X		D350-591-119	<i>Heli-Access-Step</i> ™, Long Step – Low Skid
		X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
	1		D2355	STEP ASSEMBLY (LOW-LONG)
		1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
2	2		D2171	CLAMP
2	2		D2182B035	CUSHION
		4	D2230-1	MOUNTING LUG
		4	D2230-3	MOUNTING LUG
4	4		D2274	RADIUS BLOCK
1			D2362-041	SUPPORT BRACKET
	1		D2362-3	SUPPORT BRACKET
		1	D2945	MOUNTING PLATE
1	1		D3595-200-300	CUSHION
		8	D2732-030	CUSHION
	2		AN3-37A	BOLT
		2	AN4-7A	BOLT
		4	AN4-11A	BOLT
		8	AN4-16A	BOLT
	4		AN4-21A	BOLT
4	1		AN4-22A	BOLT
	4		NAS1149D0363J	WASHER (AN960JD10)
4	6	14	NAS1149D0463J	WASHER (AN960JD416)
	2		MS21042L3	NUT
4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
2	2	2	2	D2732-030	CUSHION
2	2	2	2	AN3-37A	BOLT
1	1	1	1	AN4-13A	BOLT
2	2	2	2	AN4-16A	BOLT
4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT